

Work Order ID 86090

June-20-12 12:59:13 PM

86090

Page 1

Item ID: D3017-041

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Frame Assembly

Start Date: 20/06/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12/06/20 Tooling:

Run Start ***NR1***

QC: Date: SPC (Y/N):

Date:

Stop ***NR2***

Date:

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

Draw Nbr Revision Nbr

D3017 Rev B

100 Weld per dwg A/R 4130 rod Batch: M 118875 0.00

100

Large Fab

Large Fab

Large Fab

Memo

0.00

1-Cut D3017-1, D3017-3 and D3017-5 tubes as per Dwg D3017

2-Bend D3017-1 and D3017-3 tube as per dwg D3017 (DT8598)

3-Drill holes in D3017-5 Using DT8622

4-Deburr

5-Assemble and weld as per Dwg D3017 using Welding Jig DT8598

6-Drill holes in back frame using DT8621

① 12-7-12

110 QC9- Inspect visual per QSI004- Fusion Welds 0.00

110

QC

Quality Control

Memo

0.00

1 8 12/07/09

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

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Customer:

Reference:

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Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC5- Inspect part completeness to step on W/O

0.00

120

QC

Memo

0.00

8.26/16

Quality Control

130

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

130

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

11:00
320°F
11:30

IX ~~φ~~ MZ 12/07/10

140

QC3- Inspect Part Finish

0.00

140

QC

Memo

0.00

Quality Control

1 ~~φ~~ 12-7-10

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Page 3

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Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Back Frame Assembly

Start Date: 20/06/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 04/07/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling:

Run Start ***NR1***

QC: Date:

SPC (Y/N):

Date:

Stop ***NR2***

Date:

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

| Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|---------|--------|-----------|------------|------------|---------------|-------------|
|---------|--------|-----------|------------|------------|---------------|-------------|

150

Identify as per dwg & Stock Location: G.A

0.00

150

Packaging

Memo

0.00

Packaging

160

QC21- Final Inspection - Work Order Release

0.00

160

QC

Memo

0.00

Quality Control

12/17/18 *[Signature]*
MCS 12/07/10

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NOTE: Date & initial all entries

Picklist Print

June-20-12 12:59:17 PM

Page 1

Work Order ID: 86090

86090

Parent Item: D3017-041

D3017-041

Parent Item Name: Back Frame Assembly

Start Date: 20/06/2012

Required Date: 04/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP A01.09.19New issue EC
IPP RevB: as per revB DD verified by:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| M4130NT0.750W.083 | | Purchased | | No | | 100 | f | 37.8970 | 2.458 | 2.587368 | | | |

M4130NT0 750W 083

4130 RD Tube .750 x.083W

**

Q 12-7-12

Location

Loc Qty

Loc Code

MAT033

37.897

117579

13.98

117973

23.917

2.58

M4130NT0.750W.049

Purchased

No

100

f

105.9200

11.125

11.71053

M4130NT0 750W 049

4130 RD Tube .750 x.049W

**

Q 12-7-12

Location

Loc Qty

Loc Code

MAT033

105.92

120350

65.61

121025

40.31

11.7

D3017-11

Manufactured

No

100

Each

50.0000

2

2

D3017-11

cap

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA021

50

76851

50

2

D3017-7

Manufactured

No

100

Each

6.0000

3

3

D3017-7

Lug

**

Q 12-7-12

Location

Loc Qty

Loc Code

WA021

6

70905

6

3

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

| ITEM No. | QTY | PART NUMBER | DESCRIPTION |
|----------|-----|-------------|---------------------|
| 1 | X | D3017-041 | BACK FRAME ASSEMBLY |
| 2 | 1 | D3017-1 | TUBE |
| 3 | 1 | D3017-3 | TUBE |
| 4 | 1 | D3017-5 | TUBE |
| 5 | 3 | D3017-7 | LUG |
| 6 | 2 | D3017-11 | END CAP |

DRILL Ø0.128 HOLES TO LINE UP
WITH D3023-1 BACK PANEL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 86090 ULJ
12/06/20

RELEASED
2010-02-02
wp

| | | | |
|-----------|---|-----|----------|
| B | REFORMAT DWG, -5 TUBE WALL THKNS REVD (A8-3) SHEET 3 & 4 ADDED TO CLARIFY DRAWING. RADIUS CHANGED FROM R4.00 TO R3.75 (B4-2, B2-2). HOLE SIZE CHANGED FROM Ø0.191 TO Ø0.257 (C6-3, C3-3) | JPH | 10.01.13 |
| A | NEW ISSUE | CP | 01.05.18 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | | | |
| DRAWN | | | |
| CHECKED | | | |
| MFG APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.01.13 | | |

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO. **D3017** REV. B
SHEET 1 OF 4
TITLE **BACK FRAME ASSEMBLY** SCALE NTS

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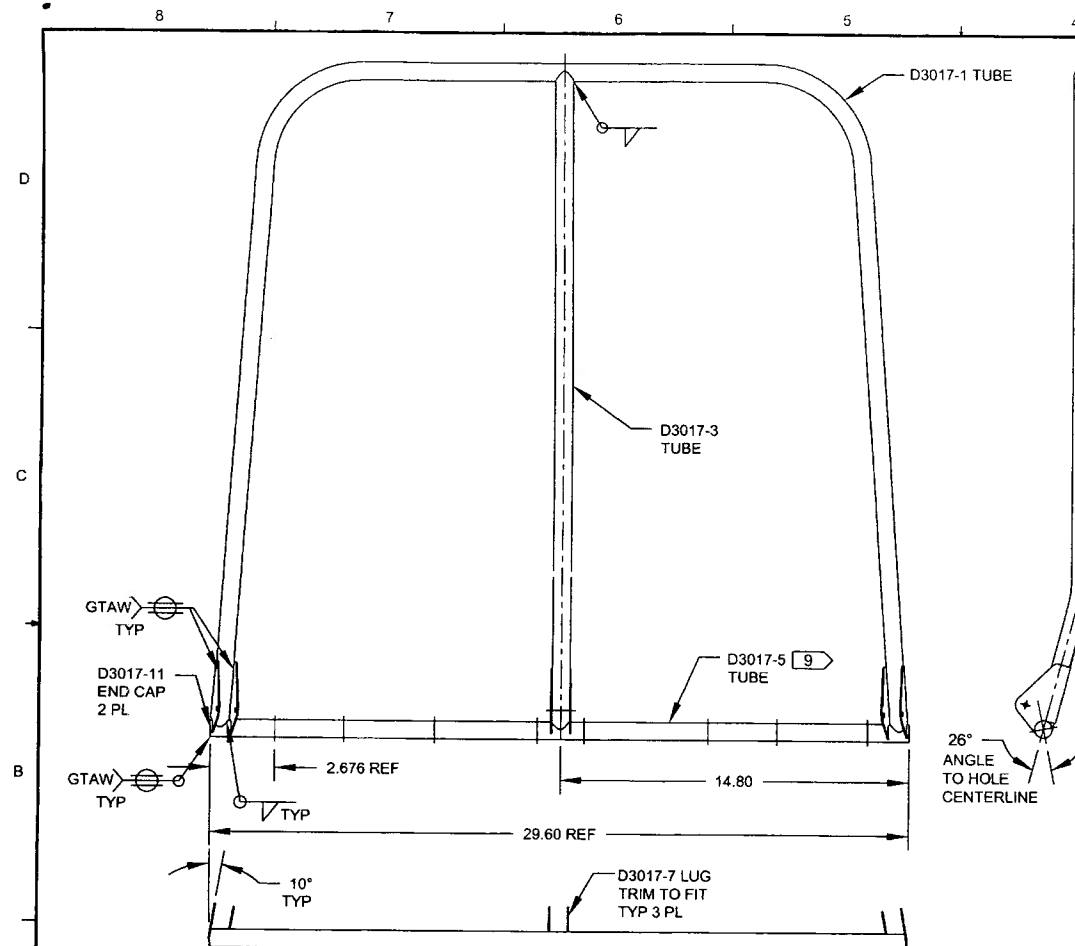
D3017-041 BACK FRAME ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3017-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 4.50 lbs
- 8) WELD PER DART QSI 004

9) ROTATE SO THAT PILOT HOLES ARE ANGLED AS SHOWN IN END VIEW.

26°
ANGLE
TO HOLE
CENTERLINE



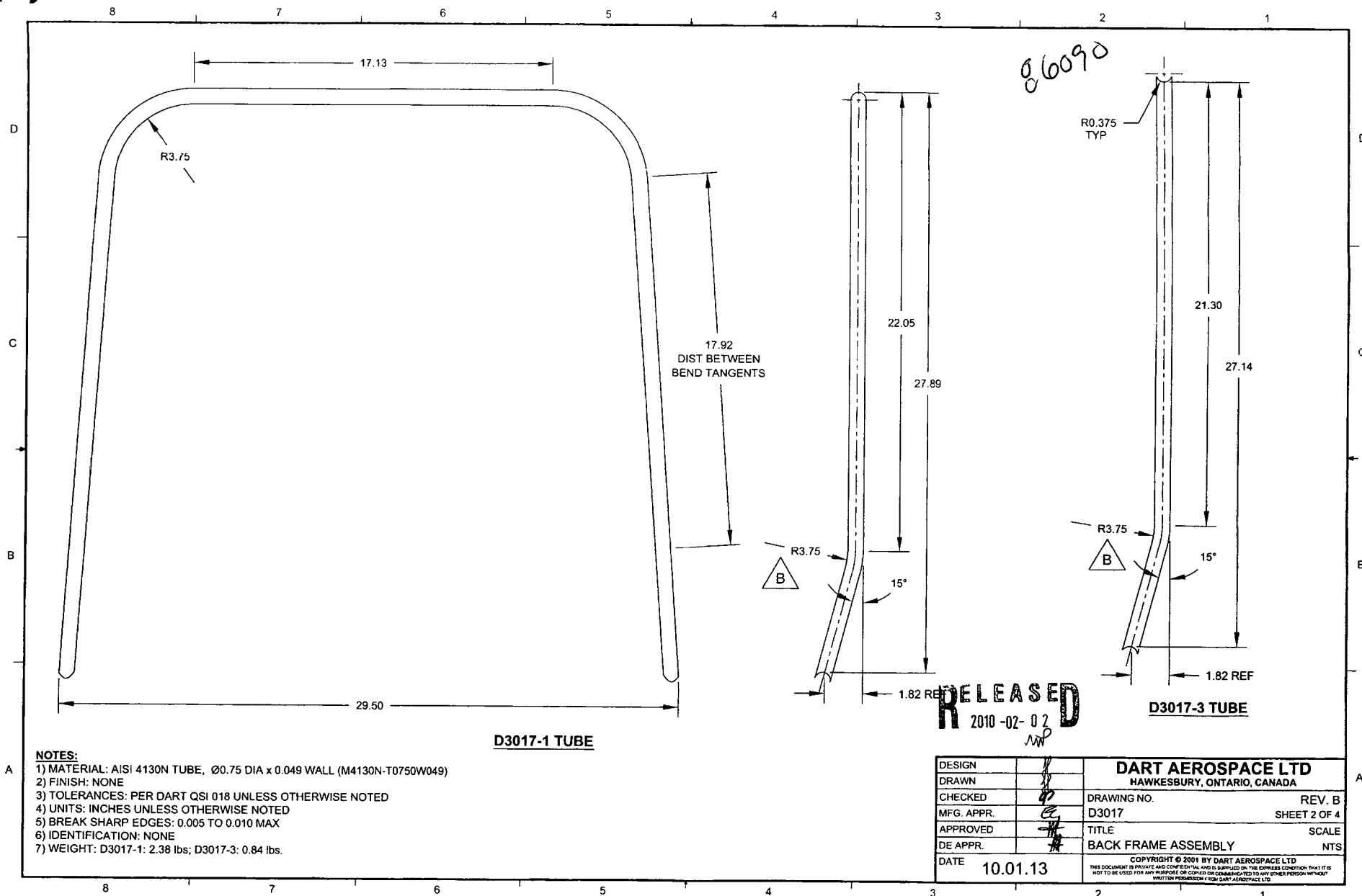
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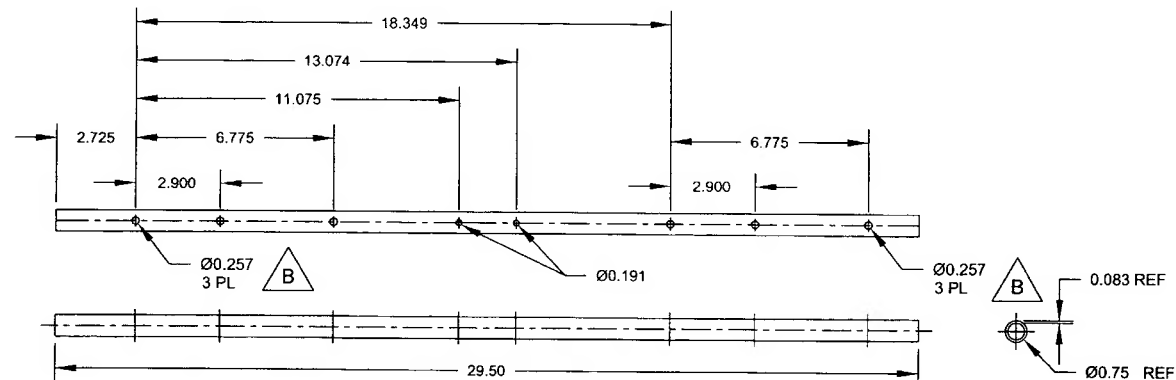
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NOTE: Date & initial all entries

86096



D3017-5 TUBE

RELEASED
2010-02-02
MD

NOTES:

- 1) MATERIAL: AISI 4130N TUBE, Ø0.75 DIA x 0.083 WALL (M4130N-T0750W083)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.89 lbs



| | | | |
|------------|----------|--|--------------|
| DESIGN | | DART AEROSPACE LTD | |
| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3017 | SHEET 3 OF 4 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | BACK FRAME ASSEMBLY | NTS |
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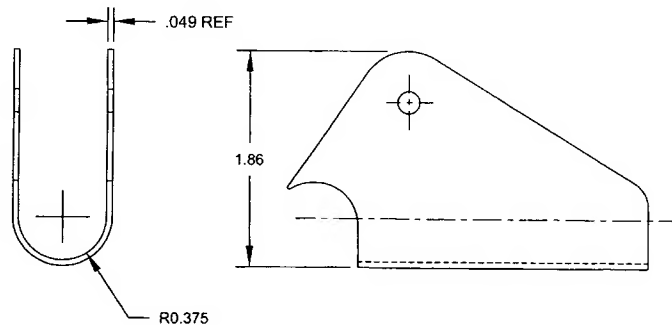
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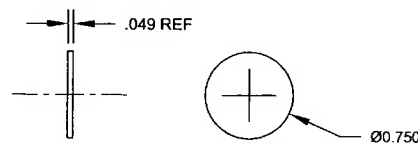
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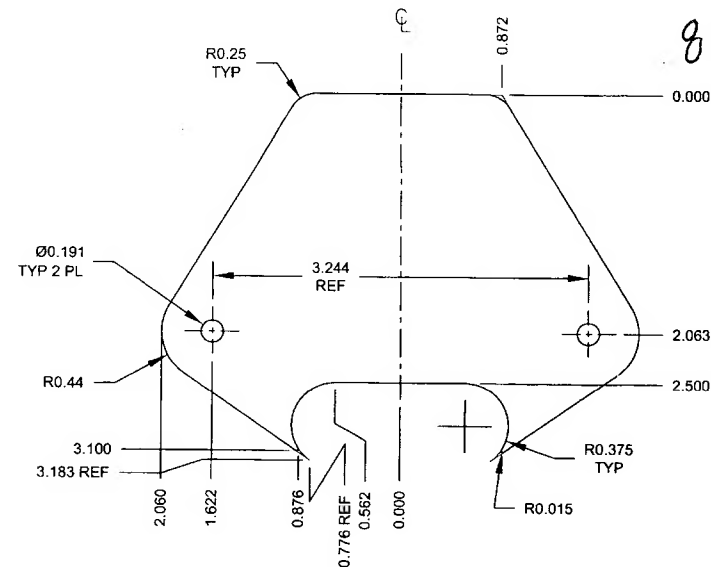
NOTE: Date & initial all entries



D3017-7 LUG
BENDING DETAIL
MAKE FROM D3017-7F



D3017-11 END CAP



D3017-7F FLAT PATTERN
PART IS SYMMETRIC
ABOUT CENTERLINE

RELEASED
2010-02-02

NOTES:

- 1) MATERIAL: AISI 4130N SHEET, 18 GAUGE (M4130N-S049)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: -7: 0.12 lbs; -11: 0.01 lbs.

| | | | |
|--|----------|--|--------------|
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| DRAWN | | HAWKESBURY, ONTARIO, CANADA | |
| CHECKED | | DRAWING NO. | REV. B |
| MFG. APPR. | | D3017 | SHEET 4 OF 4 |
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